

Work Order ID 75513

October-24-11 11:51:01 AM

75513*Eagle*

Page 1

Item ID: D4207-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Window Retainer

Start Date: 24/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 27/10/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J. Date: 11/10/24 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4207	A								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

2024.040Dwg Rev: AProg Rev: A

2-Deburr if necessary

B11-10-25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B11-10-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75513

October-24-11 11:51:01 AM

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 24/10/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 27/10/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

120

0.00

QC

Memo

Quality Control

0.00

130

0.00

HandFinish

Memo

Hand Finishing

0.00

135

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
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75513

October-24-11 11:51:01 AM

N900040100

Stop ***NS2***

Customer:

Run Start *NR1*

Stop ***NR2***

0.00


0.00

Packaging

0.00

0.00

Quality Control

n/w/27 

mf
11-10c

W/O:		WORK ORDER CHANGES					
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Picklist Print

October-24-11 11:51:06 AM

Page 1

Work Order ID: 75513

75513

Parent Item: D4207-1

D4207-1

Parent Item Name: Window Retainer

Start Date: 24/10/2011

Required Date: 27/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	110.5184	1.148	1.208421			

M2024T3S 040

2024-T3 .040 sheet

Bld-10-25

Location

Loc Qty

Loc Code

MAT022

110.518421

113162

1.1

117684

109.418421

117684

(1)

W/O:		WORK ORDER CHANGES					
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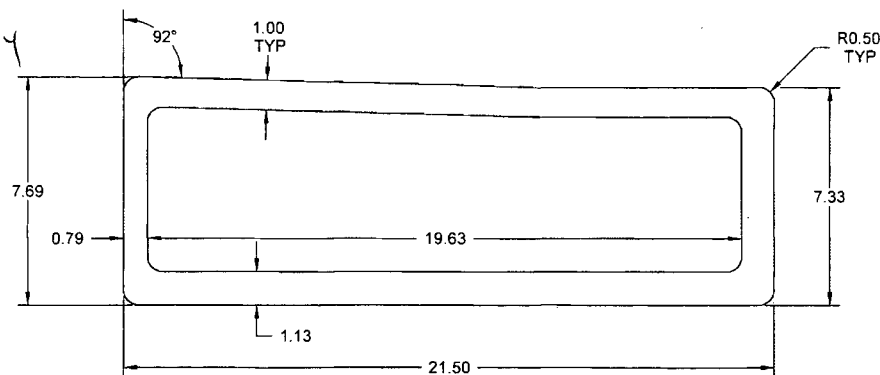
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 75513 M.L.J
11/10/24



D4207-1 WINDOW RETAINER
 (REF. EAGLE DRAWING No. D2046902 P/N EA20469-14)

RELEASED
 2011-04-06
 JW

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
 QQ-A-250/4 OR AMS-QQ-A-250/4
 OR AMS 4037
 OR ASTM B209
 PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.22 lbs

A	NEW ISSUE	RF	10.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.22		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D4207	SHEET 1 OF 2
TITLE VRD PARTS	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

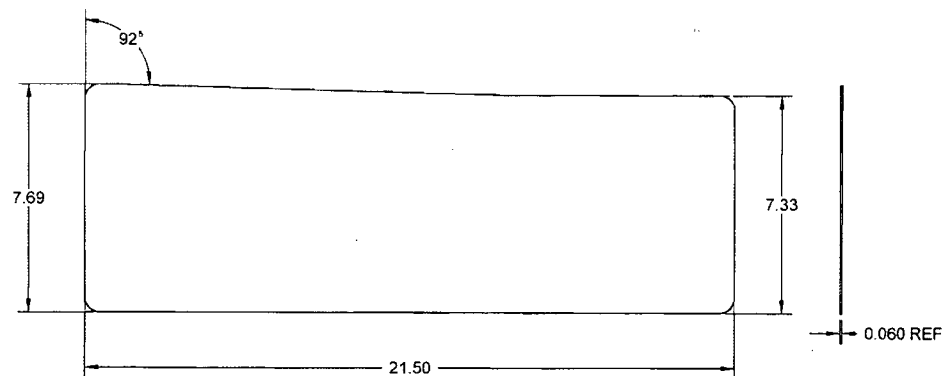
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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75513







D4207-3 INSTRUMENT WINDOW
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-13)

RELEASED
2011-04-06
JW

NOTES:

- 1) MATERIAL: GE PLASTICS LEXAN, 0.060 THICK, SMOOTH, CLEAR SHEET
REF DART SPEC. MLEXS.060-9034-08 OR MLEXS.060-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.41 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4207	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
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